

Blue shp Aug 8

Work Order ID 72515

Wednesday, July 27, 2011 2:39:08 PM



Item ID:	D2932-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle RH Out, 206					
Start Date:	7/27/2011	Start Qty:	3.00	Cust Item ID:		
Required Date:	7/29/2011	Req'd Qty:	3.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2932	Rev C								

100		HAAS CNC VERTICAL MACHINING #1	0.00		11.8.3				
HAAS 1		Memo	0.00						

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110		CONVENTIONAL MILLING MACHINE	0.00		11.8.3				
Mill Conv		Memo	0.00						

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120		QC1- Inspect dimensions to dimension sheet	0.00		11.8.3				
QC		Memo	0.00						

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2932-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 7/27/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

ent 11/08/03

QC

Memo

0.00

3

5

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

85

11.08-04

Hand Finishing

QC3 finish inspection

3 p 11/08/03

155

0.00

SprayPaint

Memo

0.00

45

11-08-04 r3

Spray Painting

PRIME B *117319*
DELFLEET BLUE B *118395*
CLEAR B *118053*

W/O:		WORK ORDER CHANGES					
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Start Date: 7/27/2011 Start Qty: 3.00



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Required Date: 7/29/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

165 QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

③

11-08-05

170 Identify as per dwg & Stock Location: ST 421

0.00



Packaging

Memo

0.00

Packaging

③ JBS 11/08/05

180 QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/09

11-08-9
③

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 27, 2011 2:39:05 PM

Page 1

Work Order ID: 72515



Parent Item: D2932-2



Parent Item Name: Saddle RH Out, 206

Start Date: 7/27/2011

Required Date: 7/29/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP: B□00.06.26□New DWG rev (mpp 2069)□EC
IPP Rev:C As per Rev C 07-03-19 JLM □

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-003 Manufactured No

100

Each

11.0000

1

3



Saddle Billet, 7075

DP 11.8.3

Location

Loc Qty

Loc Code

MAT040

1

69678

1

MAT44

10

70978 ✓

10

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 72515
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

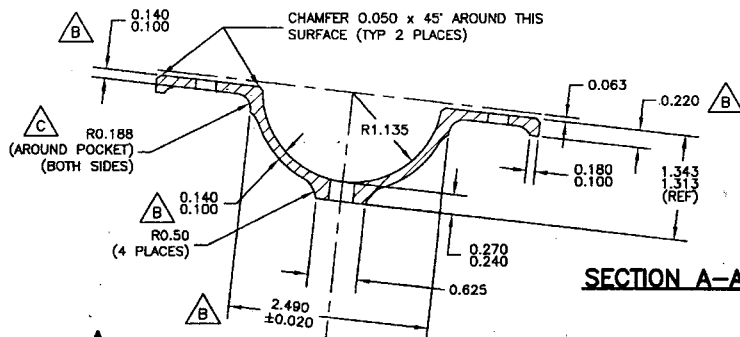
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.110	.110	.110			
B	0.100	0.140		.110	.110	.110			
C	0.100	0.140		.115	.115	.115			
D	0.210	0.230		.220	.215	.215			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.511	.511	.511			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.257	.257	.257			
L	0.312	0.317		.313	.313	.313			
M	0.235	0.240		.238	.238	.238			
N	0.100	0.140		.110	.110	.110			
O	0.540	0.560		.550	.550	.550			
P	0.490	0.510		.505	.505	.505			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.495	2.495	2.495			
S	0.240	0.270		.255	.255	.255			
T	0.100	0.180		.140	.140	.140			
U	1.625	1.635		1.630	1.630	1.630			
V	1.362	1.372		1.358	1.358	1.358			
W	0.316	0.321		.316	.316	.316			
X	1.125	1.145		1.130	1.130	1.130			
Y	1.565	1.585		1.570	1.570	1.570			
Z	0.178	0.198		.188	.188	.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

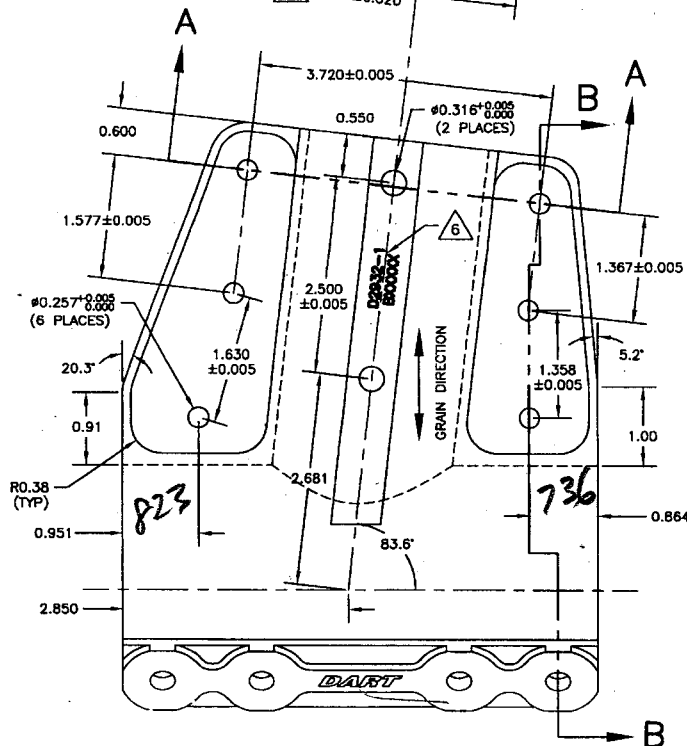
Measured by: <i>RR</i>
Date: 11-8-3

Audited by: <i>cmf</i>
Date: 11/08/03

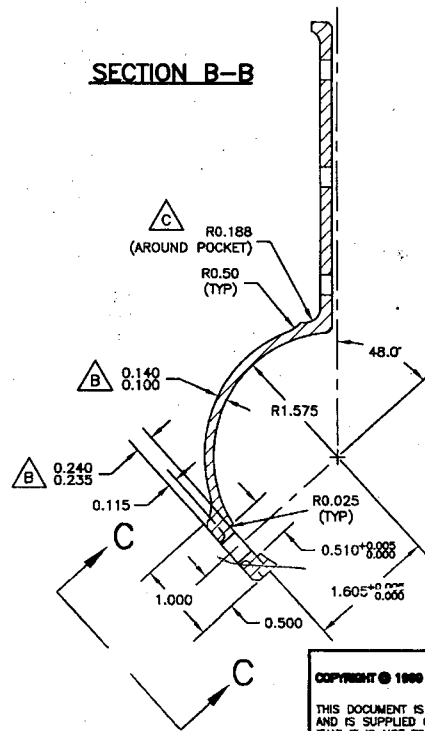
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



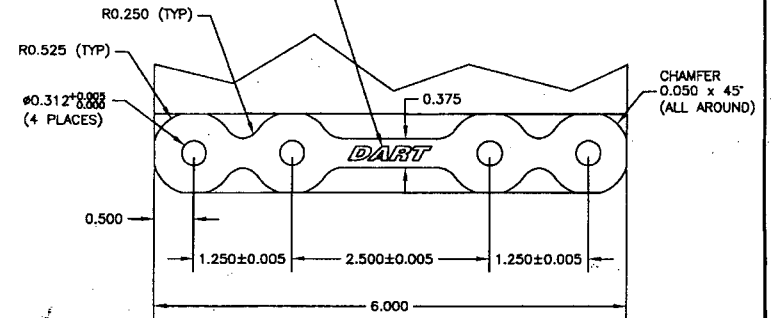
SECTION A-A



SECTION B-B



ENGRAVE DART LOGO TO MAX DEPTH OF 0.005 WITH MIN RAD 0.250



VIEW C-C

D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE OUTSIDE
		SCALE
		2:3

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DART DART AEROSPACE USA, INC.
BELLINGHAM, WA

DRAWING NO. D2932 REV. C SHEET 1 OF 1

RELEASED
07-02-12

W/O:		WORK ORDER CHANGES					
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